

Work Order ID 70878

Thursday, June 16, 2011 2:43:06 PM



Page 1

Item ID: D3805-045

Accept



Setup Start



Revision ID:

Item Name: Wearplate Assembly Aft, Low Gear

Stop



Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: P

Date: 11-06-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3805

A

100

0.00



Large Fab

Large Fab

Memo

0.00

1- on D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805

2059 B Hardcoat Welding Rod

BATCH#: M118453

2-weld D3806-5 to wearplate by positioning holes together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M117659

3-Transfer drill holes in bar

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Quality Control

Memo

0.00

26 11-08-23 JBL/CL

QC 11-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70878

Thursday, June 16, 2011 2:43:06 PM



Page 2

Item ID: D3805-045	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Wearplate Assembly Aft, Low Gear					
Start Date: 6/16/2011	Start Qty: 6.00		Cust Item ID:		
Required Date: 6/23/2011	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat									
Powder Coating									
Memo	3:45	0.00							
	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								
	4:15								

140	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

6X M/11/08/23

5/11/08/24 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 70878

Thursday, June 16, 2011 2:43:06 PM



Page 3

Item ID: D3805-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond D3807-5 gasket to inner surface of wearplate using a thin layer of 3m
1300/1300L scotch grip adhesive as per dwg
BATCH: 1113780

SP 11/08/24 (6)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Jul 23/24

(46) SP 11-08-29

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Finishing

SP

(Lex) SP 11-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70878

Thursday, June 16, 2011 2:43:06 PM



Page 4

Item ID: D3805-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/29 JF

11.08.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 16, 2011 2:43:12 PM

Page 1

Work Order ID: 70878

Parent Item: D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear




Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-5 		Manufactured	No	W/A	B70859	100	Each	0.0000	1	6	x6	11-08-18 JBL/KL	
Plate													
D3806-5 		Manufactured	No	W/A	B70860	100	Each	2.0000	1	6	x6	11-08-18 JBL/KL	
Bar													
<div> <div>Location</div> <div>WA030</div> <div>46781</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3807-5 		Manufactured	No			150	Each	0.0000	1	6		6/11/08/24	
Gasket													

B70861 (6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

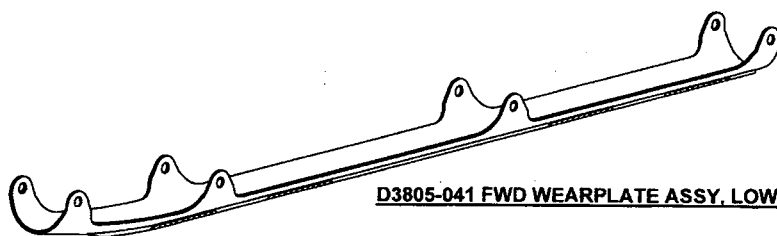
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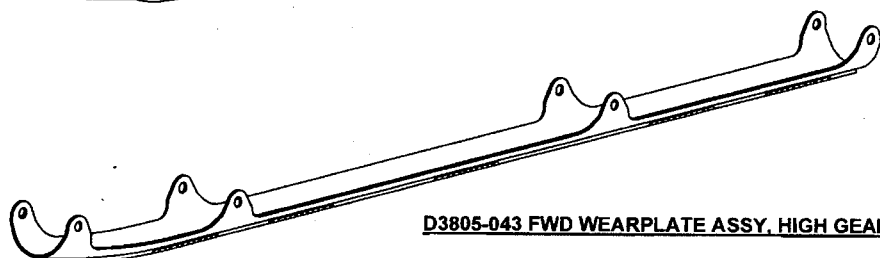
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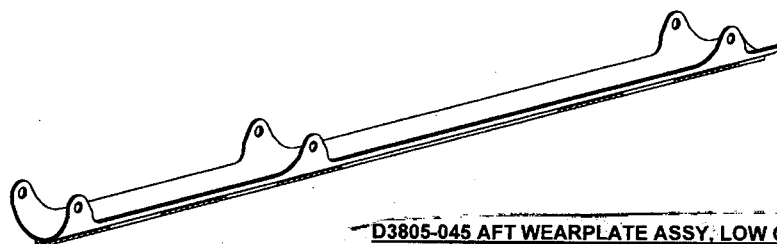
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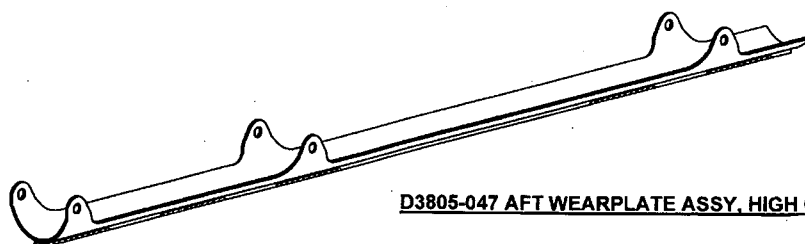
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70878

PL 11-06-16

RELEASED
47 07.03.03

per ECN 09-538

UNDER REVIEW

11.08.19

PER PART 100

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.21		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3805**

TITLE **WEARPLATE ASSY**

REV. A
SHEET 1 OF 8
SCALE
NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

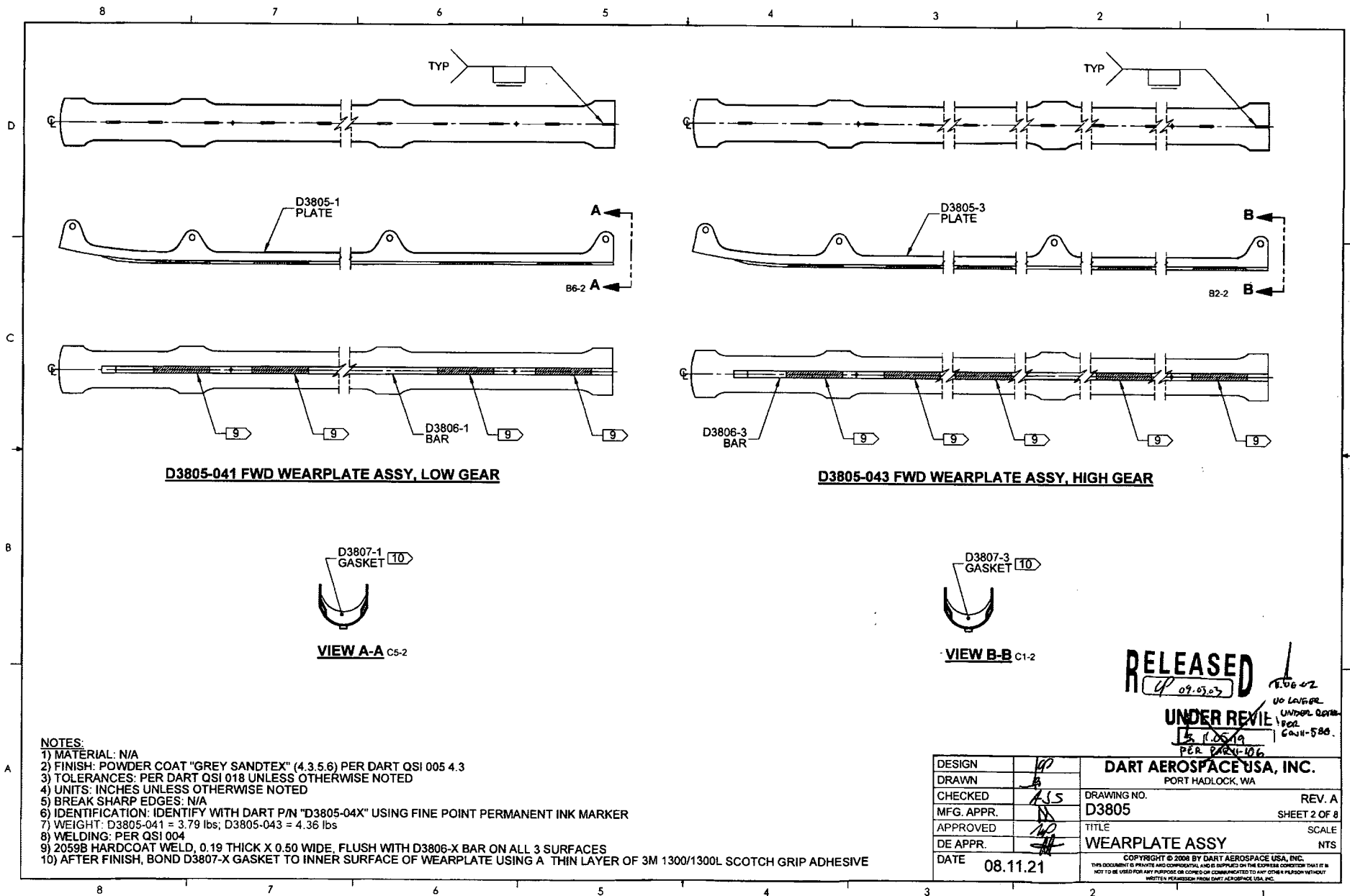
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O 70828



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

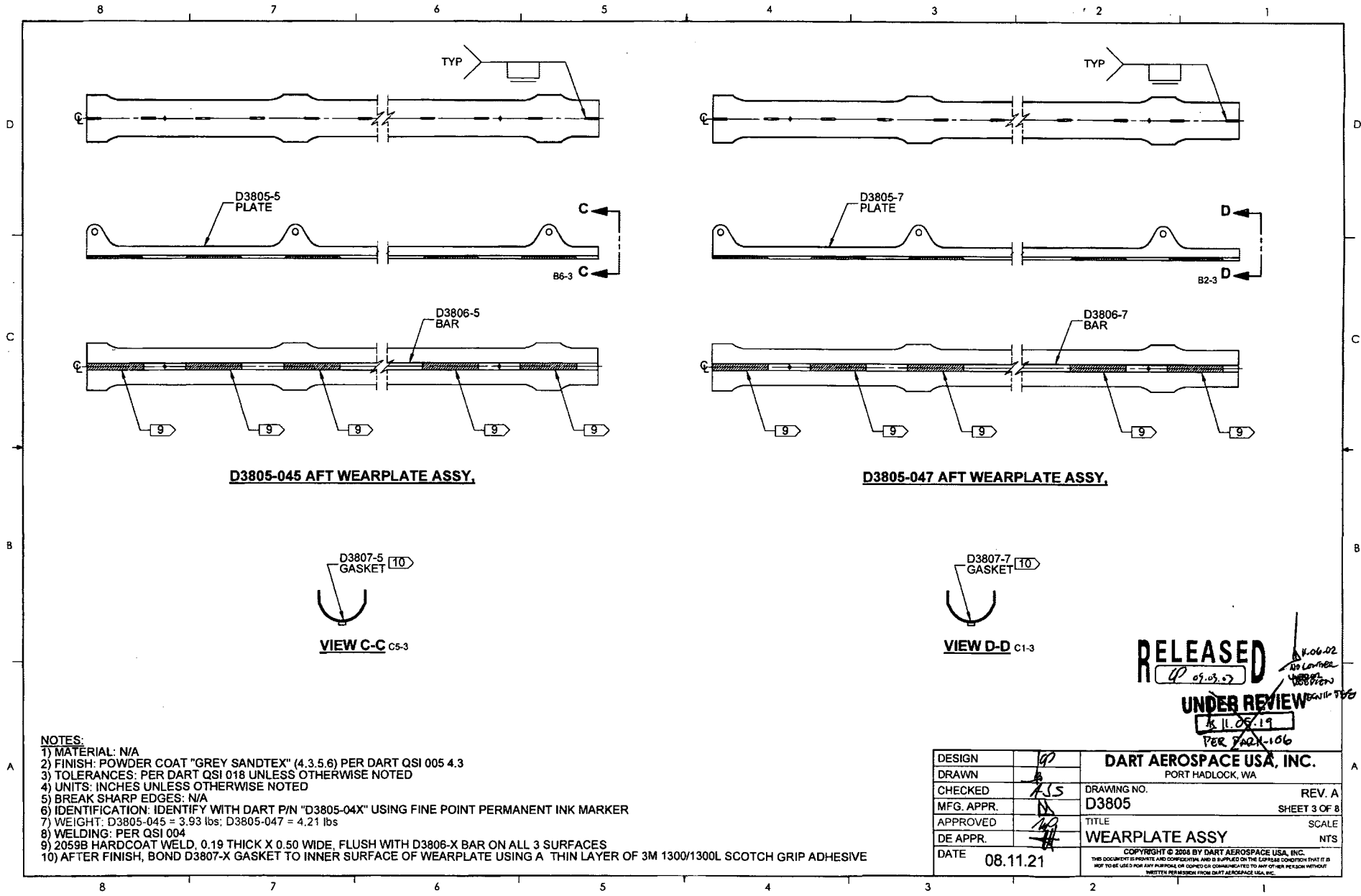
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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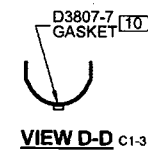
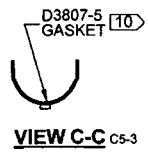
NOTE: Date & initial all entries

u/o 70876



D3805-045 AFT WEARPLATE ASSY.

D3805-047 AFT WEARPLATE ASSY.



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

RELEASED
 09.03.07
UNDER REVIEW
 11.08.19
 PER 702X-106

DESIGN	10	DART AEROSPACE USA, INC.	
DRAWN	15	PORT HADLOCK, WA	
CHECKED	15	DRAWING NO.	REV. A
MFG. APPR.	15	D3805	SHEET 3 OF 8
APPROVED	15	TITLE	SCALE
DE APPR.	15	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

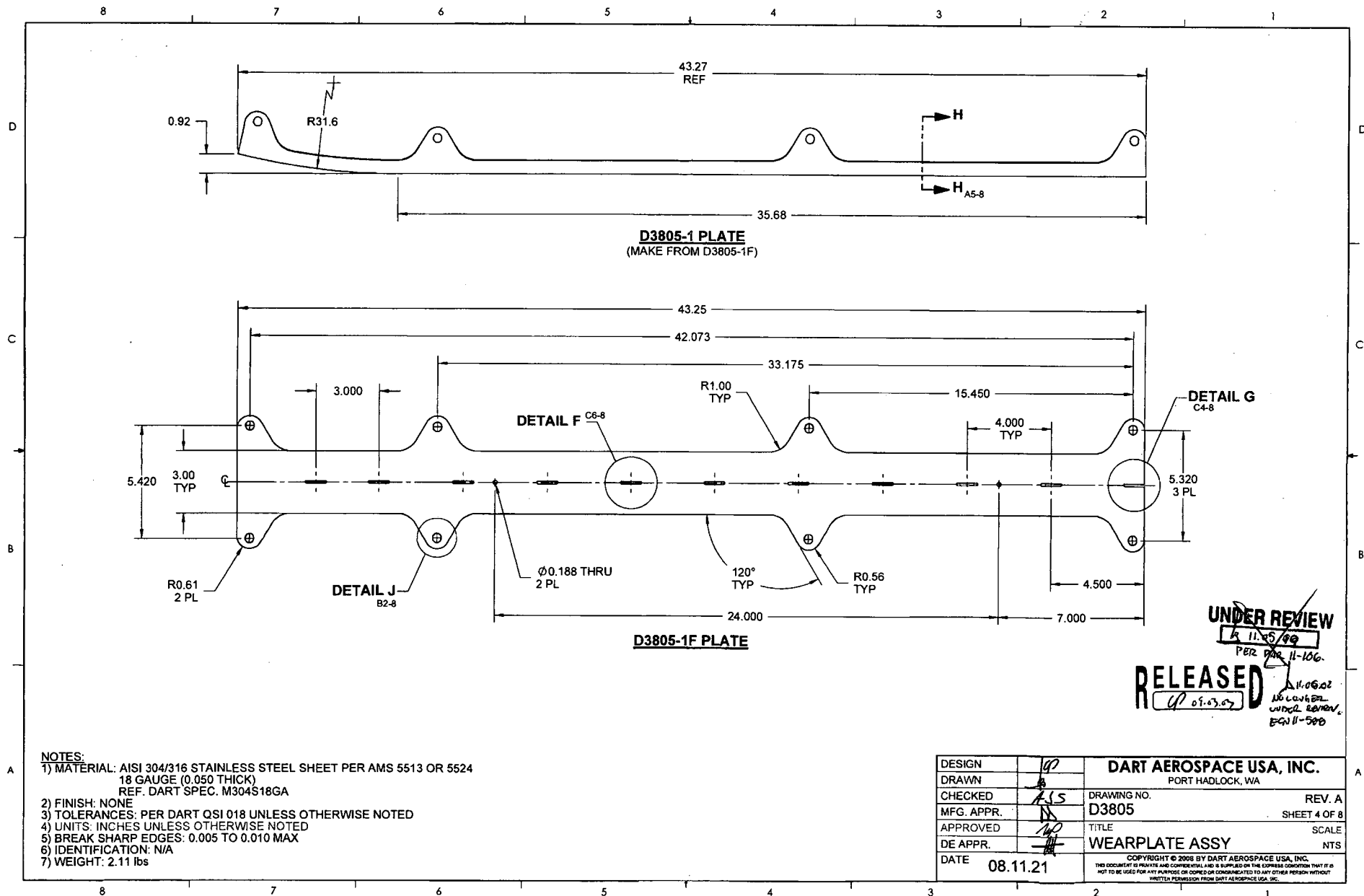
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ULO 70878



W/O:		WORK ORDER CHANGES					
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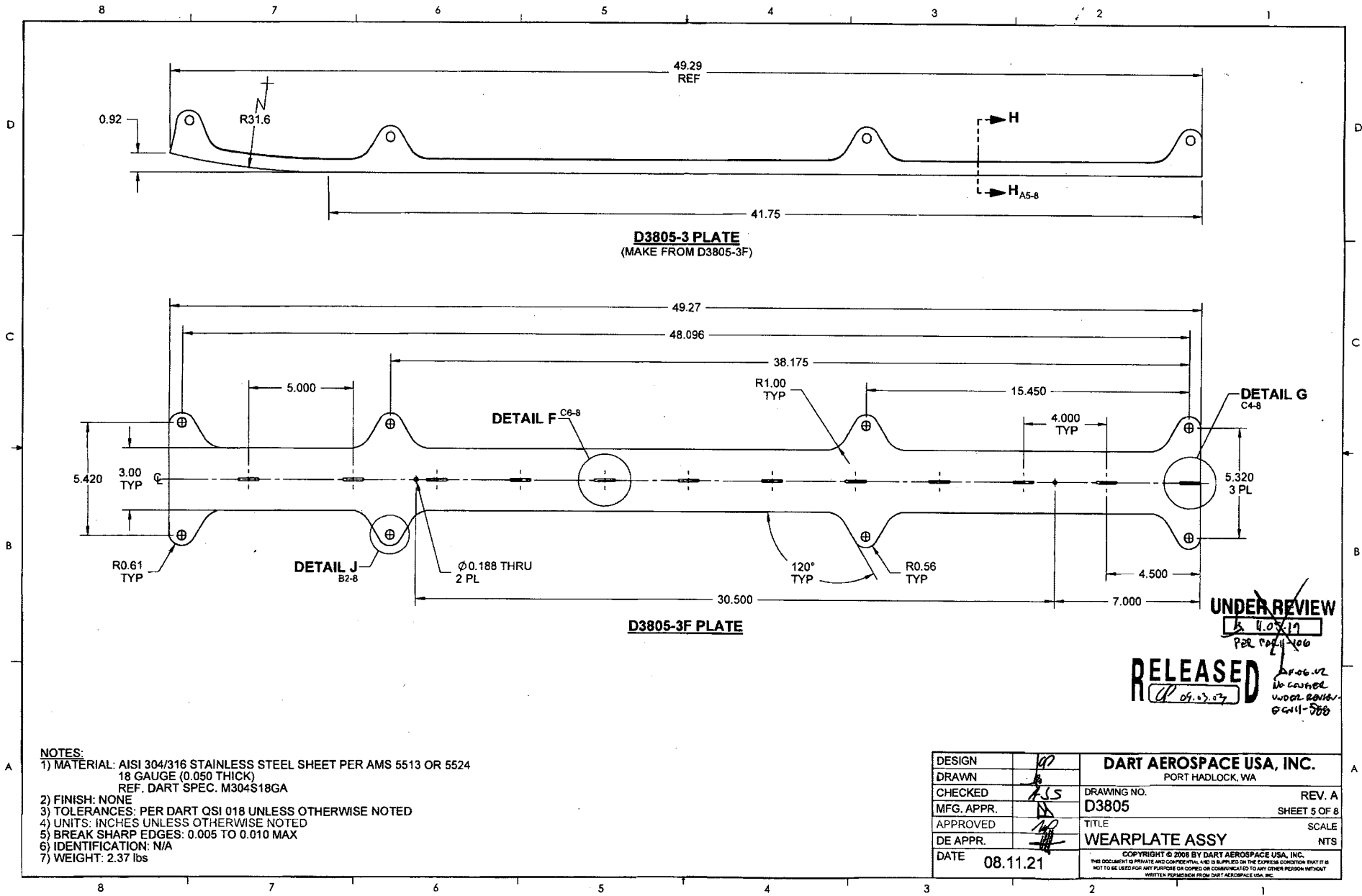
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

u/o 70878



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

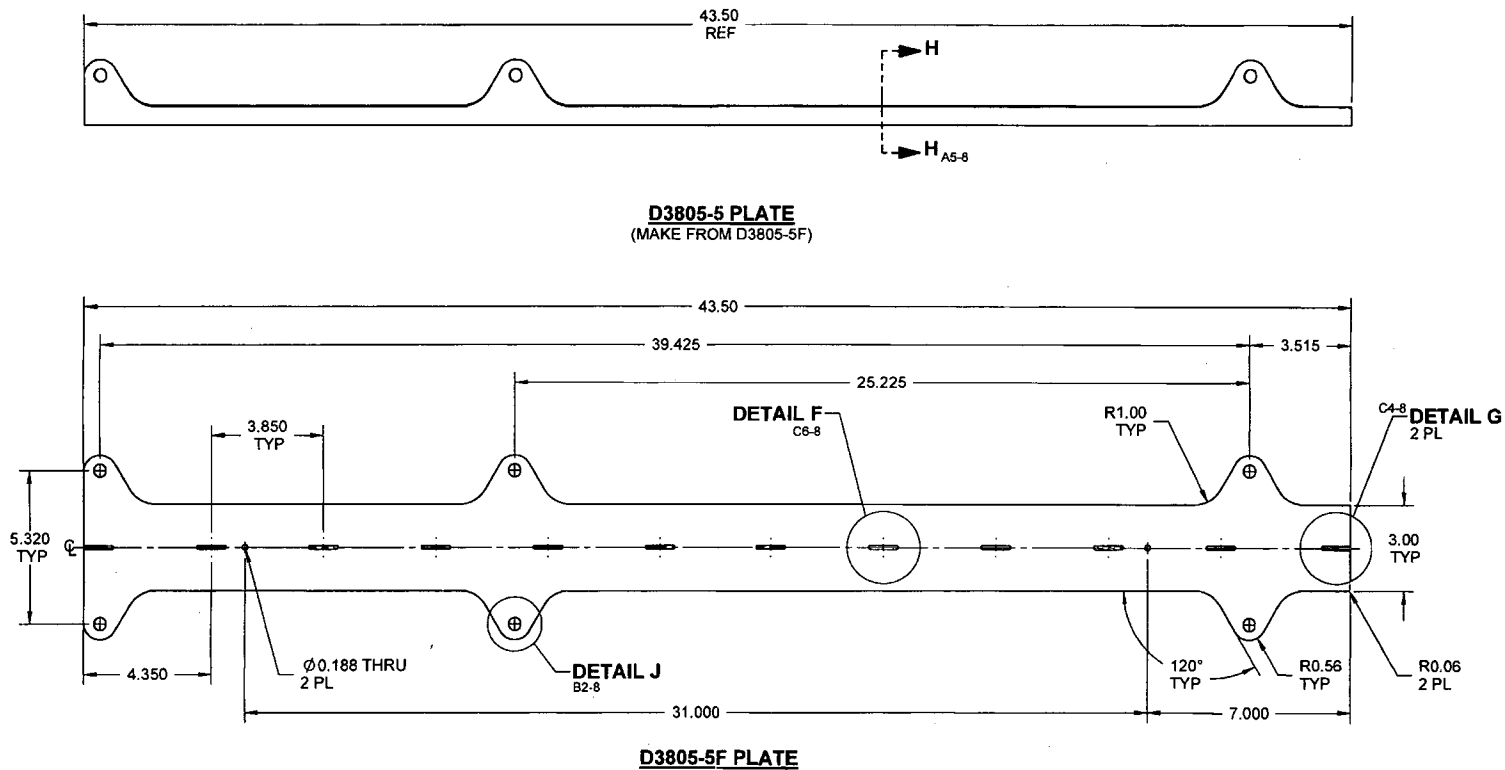
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

u/b 70878



RELEASED
07 04 03 03
UNDER REVIEW
05 05 19

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.06 lbs

DESIGN	197	DART AEROSPACE USA, INC.	
DRAWN	B	PORT HADLOCK, WA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	N	D3805	SHEET 6 OF 8
APPROVED	40	TITLE	SCALE
DE APPR.	40	WEARPLATE ASSY	NTS
DATE	08.11.21	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

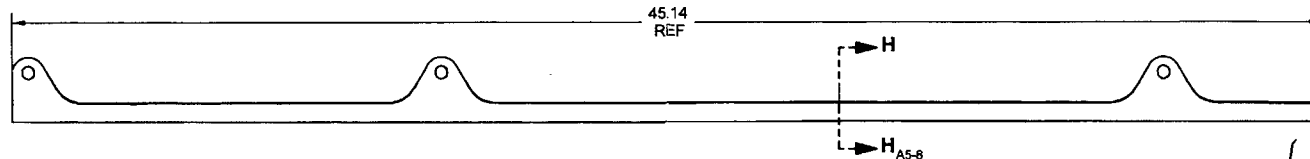
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

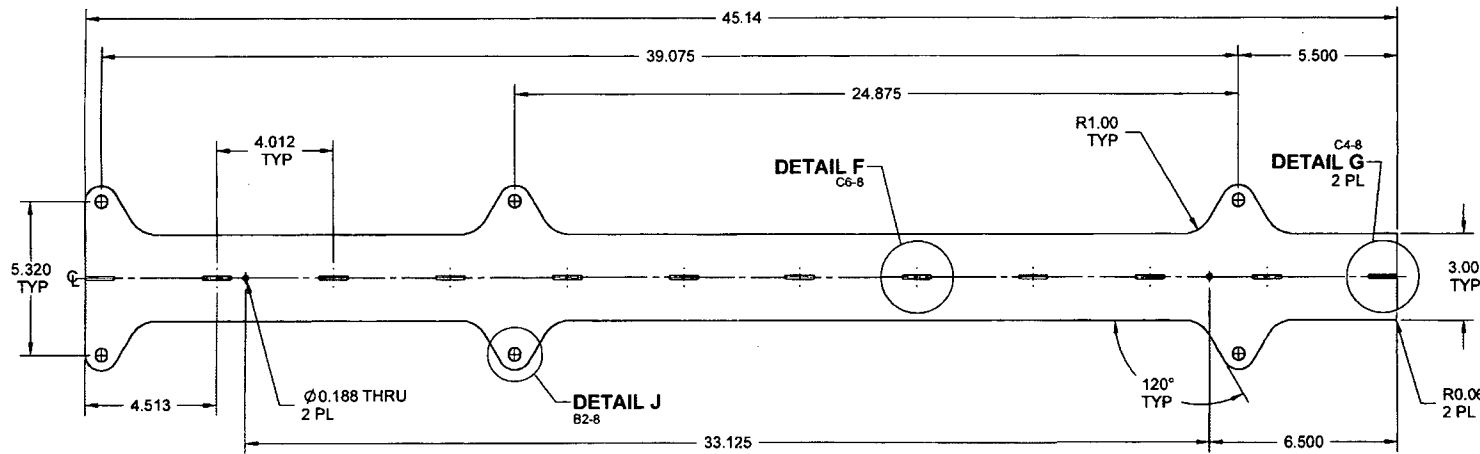
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)

W/O 70878



D3805-7F PLATE

RELEASED
09.02.23

*11.00.02
12.10.02
1000.00.00
00.11.566*

UNDER REVIEW

13.11.09.14 FOR PAR 1-106

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	<i>1P</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>1P</i>	PORT HADLOCK, WA	
CHECKED	<i>1S</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>1S</i>	D3805	SHEET 7 OF 8
APPROVED	<i>1P</i>	TITLE	SCALE
DE APPR.	<i>1P</i>	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

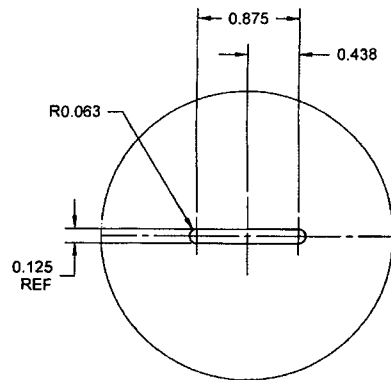
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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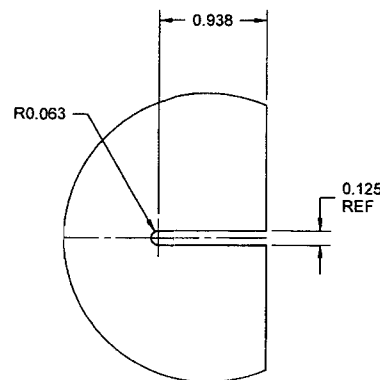
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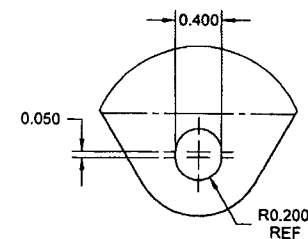
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



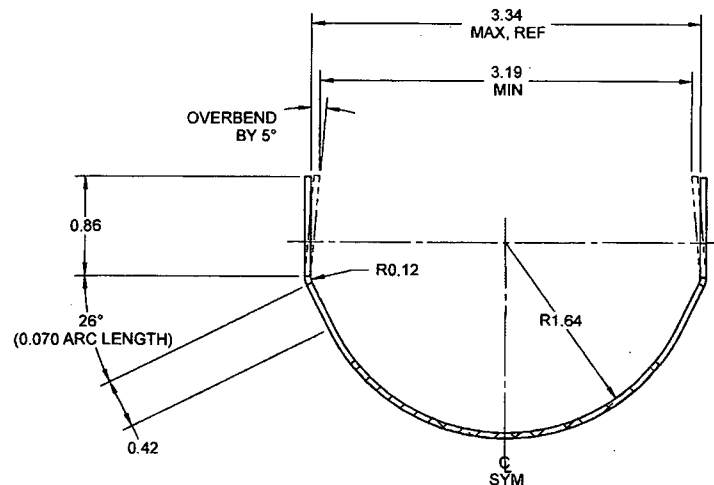
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

RELEASED
49-07-03-03

UNDER REVIEW

PER 1004-106

DESIGN	197	DART AEROSPACE USA, INC.	
DRAWN	A	PORT HADLOCK, WA	
CHECKED	ALS	DRAWING NO. D3805	REV. A
MFG. APPR.	NS		SHEET 8 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries